

Monday, 11/13/2006 12:40:09 PM
Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 29436	Part Number	: D23623
Estimate Number	: 10260	Drawing Number	: D2362 REV E1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/13/2006 S.O. No. : N/A	Drawing Revision	: E1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 11/20/2006
Previous Run	: 29435	Qty:	8 Um: Each
Written By	: <i>[Signature]</i> 06-11-13		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: G 00.05.18 Added inspection level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	B29079

En 06/11/13 x 8

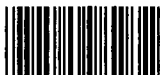
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

En 06/11/13 x 8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

En 06/11/13 x 8

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/11/13 x 8

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

En 06/11/13 x 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 29436

Part Number: D23623

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

Q.M. 06/11/30 (8)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

SB 06/12/04

(8)

8.0	D23971	Rubber Cushion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number	Description	Batch
1 D2397-1	Rubber	B29445

9.0	D23973	Rubber Cushion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number	Description	Batch
1 D2397-3	Rubber	B29446

SB 06/12/04 8

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch M100374

SB 06/12/04 8

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-12-11

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

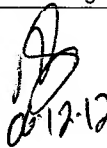
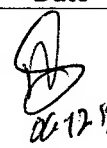
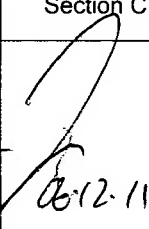
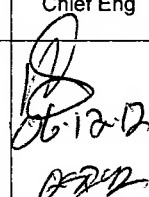

Location: _____

06/12/12 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 18 Date: 06/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-12-05	6-0	Powder coat is missing on the inside of the part. Then an error, and a hard spot to get paint into.	 06-12-12	Touch-up inside of the parts using white Incon paint. Apply in nice even coats.	 06-12-12	 06-12-11	 06-12-12	 06-12-05

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/13

Job Completion



U 06.12.13



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	<i>CP</i>	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

DESIGN OK, BUT CHECK WITH
D2397 MANUFACTURE
OK 12/11/04

0.257 X 0.75 SLOT

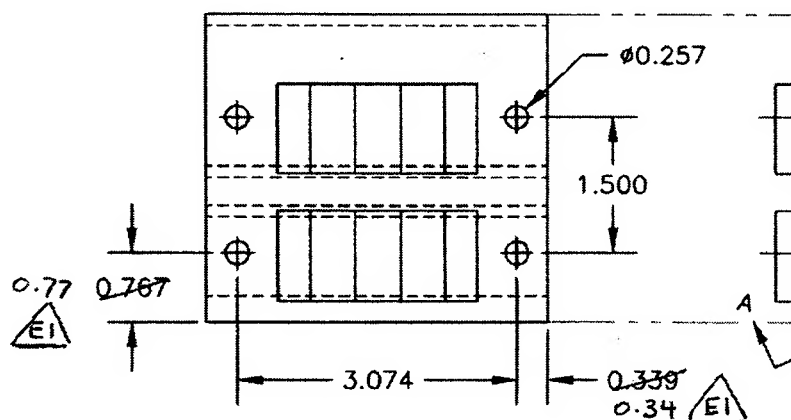
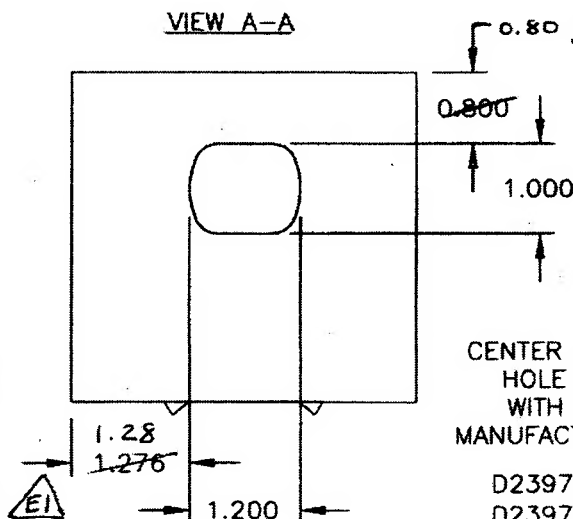
REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

REFERENCE ONLY

D2362-3



NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

